

Work Order ID 149633

Tuesday, July 26, 2016 10:19:47 AM

149633

Page 1

Item ID: D5123-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp Cushion

Start Date: 8/2/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/5/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: **DAS**Date: **JUL 27 2016**

Tooling:

Date:

Run Start ***NR1***QC: **21**
9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5123	C

100

0.00

100

Mill Conv

Memo

0.40

Conventional Milling Machine

1-Mill as per DWG

DWG REV: **C**

2-Deburr as required

12**0****DAS**
32
9-89**16-09-02**

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

12**0****DAS**
32
9-89**16-09-02**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 20 9-89 16-09-02
120						12	0		
QC	Memo	0.04							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							SEP 06 2016
130									
Packaging	Memo	0.02							
Packaging	LOCATION : LG054								
140	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89 SEP 07 2016
140									
QC	Memo	0.20							
Quality Control									

DAS
21
9-89 SEP 07 2016

DQA: _____ Date: _____



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Work Order update only ☐

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Picklist Print

Tuesday, July 26, 2016 10:19:47 AM

Work Order ID: 149633

149633

Parent Item: D5123-1

D5123-1

Parent Item Name: Clamp Cushion

Start Date: 8/2/2016

Required Date: 8/5/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 14/08/08 JLM VERIFIED BY:RQ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-1		Manufactured	No				f	35.8350		5.178947			DAS
D4287-1									**			16-08-30	32 9-89
Uhmw U-Channel													

Location

Loc Qty

Loc Code

ST479a

35.835

144485

9.406

146823

26.429

5.187

DQA: _____ Date: _____

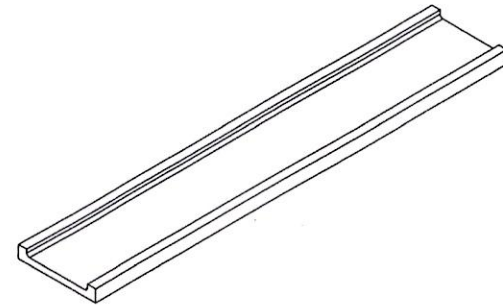


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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

149633 MJS
160727

RELEASE

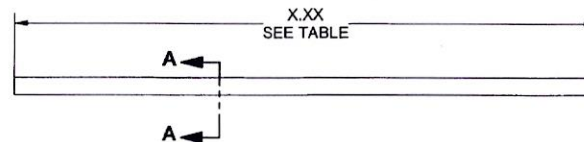
2015 MAR 18
P EGN 15-547

C	ADD D5123-7	CP	15.01.21
B	ADDED D5123-5 CLAMP CUSHION, ADDED TABLE, ADDED THICKNESS TO PART	AP	14.08.19
A	NEW ISSUE	AP	14.08.06
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	AP	DRAWING NO.	REV. C
MFG. APPR.	JLM	D5123	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CLAMP CUSHION	NTS
DATE	15.01.21	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

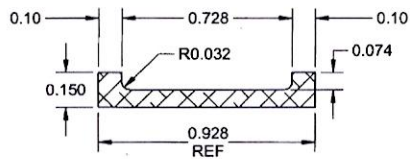
APPROVED

D5123-Y CLAMP CUSHION

PART NUMBER	LENGTH X.XX (IN)
D5123-1	5.00
D5123-3	4.25
D5123-5	6.00
D5123-7	3.95



SECTION A-A SCALE 2X



- NOTES:
- 1) MATERIAL: MAKE FROM D4287-1
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 - 7) WEIGHT: LESS THAN 0.01 lbs